

## Claims

We claim:

1. A method of making a multilayer structure for packaging bone-in meat comprising the steps of:

5           coextruding a multilayer structure comprising at least a heat sealant layer comprising a material selected from the group consisting of polyolefins, polyamides, ionomers, and blends thereof, a first polyamide layer, and a first tie layer; and

          biaxially orienting the multilayer structure.

2. The method of claim 1 further comprising the step of annealing the multilayer structure.

10       3. The method of claim 1 wherein the first tie layer is disposed between the sealant layer and the first polyamide layer.

4. The method of claim 1 wherein the first polyamide layer is disposed between the sealant layer and the first tie layer.

15       5. The method of claim 1 wherein the heat sealant layer comprises a blend of linear low density polyethylene and low density polyethylene.

6. The method of claim 1 wherein the first polyamide layer comprises a blend of semi-crystalline polyamide and amorphous polyamide.

7. The method of claim 1 wherein the first polyamide layer comprises a blend of nylon 6 and amorphous polyamide.

20       8. The method of claim 1 wherein the first polyamide layer comprises a blend of nylon 6,66 and amorphous polyamide.

9. The method of claim 1 wherein the first polyamide layer comprises a blend of a first semi-crystalline polyamide, a second semi-crystalline polyamide, and amorphous polyamide.
10. The method of claim 1 wherein the first polyamide layer comprises a blend of nylon 6,  
5 nylon 6,69 and amorphous polyamide.
11. The method of claim 1 wherein the multilayer structure further comprises a second tie layer.
12. The method of claim 1 wherein the first polyamide layer forms an outer layer of the multilayer structure.
- 10 13. The method of claim 1 further comprising the step of moisturizing the multilayer structure by applying water to the multilayer structure.
14. The method of claim 1 further comprising the step of irradiating the multilayer structure to promote crosslinking of the layers of the multilayer structure.
15. The method of claim 1 wherein the multilayer structure is between about 1 mil and  
15 about 8 mils thick.
16. The method of claim 1 wherein the multilayer structure is between about 1.5 mils and about 5 mils thick.
17. The method of claim 1 wherein the multilayer structure further comprises a second polyamide layer, and wherein the first and second polyamide layers are disposed on  
20 opposite sides of the first tie layer.
18. The method of claim 17 wherein the second polyamide layer comprises a blend of semi-crystalline polyamide and amorphous polyamide.

19. The method of claim 17 wherein the second polyamide layer comprises a blend of nylon 6 and amorphous polyamide.
20. The method of claim 17 wherein the second polyamide layer comprises a blend of nylon 6,66 and amorphous polyamide.
- 5 21. The method of claim 17 wherein the second polyamide layer comprises a blend of nylon 6, nylon 6,69 and amorphous polyamide.
22. The method of claim 17 wherein the multilayer structure further comprises an outer layer comprising a material selected from the group consisting of polyolefins, polyamides, ionomers, polyesters and blends thereof, and wherein the first polyamide layer is disposed  
10 between the first tie layer and the outer layer, and the second polyamide layer is disposed between the first tie layer and the sealant layer.
23. The method of claim 22 wherein the multilayer structure further comprises a second tie layer between the outer layer and the first polyamide layer.
24. The method of claim 22 wherein the multilayer structure further comprises a second  
15 tie layer between the sealant layer and the second polyamide layer.
25. The method of claim 22 wherein the multilayer structure comprises a second tie layer between the outer layer and the first polyamide layer and a third tie layer between the sealant layer and the second polyamide layer.
26. The method of claim 1 wherein the multilayer structure is coextruded as a tube.
- 20 27. The method of claim 1 wherein the multilayer structure is biaxially oriented by a double bubble method.
28. The method of claim 1 wherein the multilayer structure is oriented via tenter frame.